

Date: Friday, 12/9/2005 12:06:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 25189		
Estimate Number	: 11351		
P.O. Number	: N/A	Part Number	: D33405
This Issue	: 12/9/2005 S.O. No. : N/A	Drawing Number	: D3340 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/9/2005 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment below</u>	Due Date	: 12/30/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	10 Um: Each
Comment	: Est: A 05.11.10 Preliminary issue AP/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000267

Email of ship DXF file to vendor

Laser Cut per Dwg D3340 flat pattern D3340-5

Material release note required

2.0	D33405F	Wearplate
-----	---------	-----------



Comment: Qty.: 1.0000 U(s)/Unit Total: 10.0000 U(s)
 Wearshoe

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form on brake as per Dwg D3340 using Jigs DT

and DT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-01-05	4	Took 1 Ser template. Identify AS DT 8832	<i>[Signature]</i>	06-01-05	1	<i>[Signature]</i> <i>[Signature]</i>	<i>[Signature]</i> 06-01-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/9/2005 12:06:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25189

Part Number: D33405

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-01-05 9

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 06 01 12 9

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/1/13 (9) CZ

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *72*

06/01/13 (9)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/01/13 (9)

Job Completion



06.01.13 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

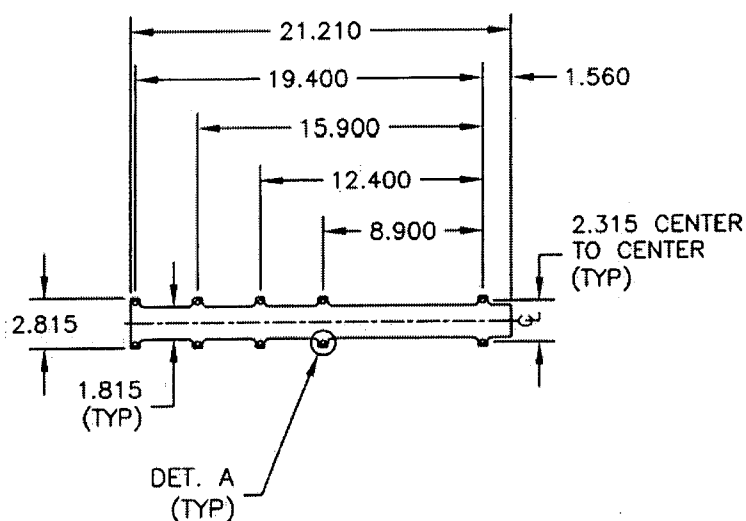
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

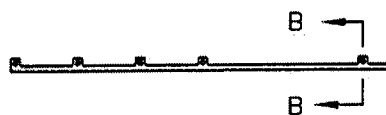


DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 3 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

RELEASED
05.11.28



D3340-5F FLAT PATTERN



D3340-5 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

SHOT COPY
RETURN TO
ENGINEERING

DATE: 05.11.28

SUBJECT TO: 005 4.3
WITHOUT NOTICE

WORK ORDER

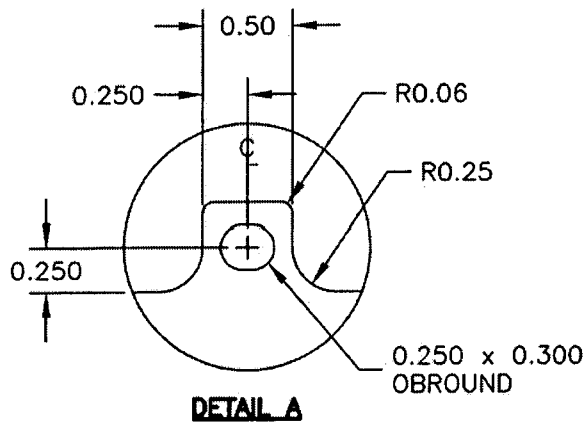
NO. 25189

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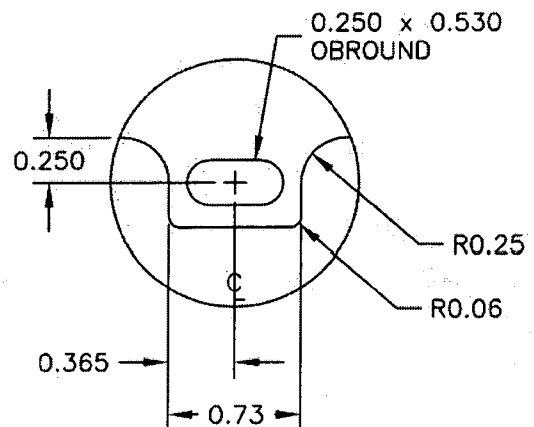
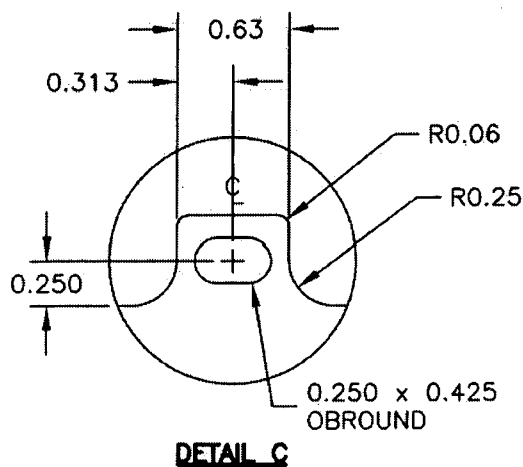
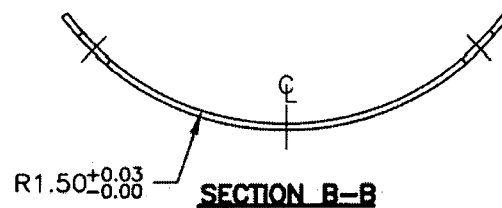
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DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



RELEASED
05-11-28 [Signature]



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FIGURE OF
WORK ORDER
NO 25189

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03/03/2005 12:44 FAX 0042129137
Integris Metals 3/3/2005 1:32 PAGE 003/004

01/18/05 TUE 15:50 FAX 604 272 0961
Integris Metals *** MTR MINNEAPOLIS 01010

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

90229754

YEH MAU CORP.
YEH MAU CORP.

INVOICE NO.
COMMODITY:

FORMAAS
PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304 NO.4 (SIC)
FINISH WITH 100 MIC FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE AISI 304 2B FINISH WITH PAPER INTERLEAVED,
SLITTED EDGE.
AISI 304

SPECIFICATION:
CUSTOMER:

INTEGRIS METALS LTD

工廠: 嘉坡基港竹脚順安路345號
345, SHUN AN RD. LI CHU SIANG
KAOHSUNG TAIWAN R.O.C.
TEL: (07) 8672885 FAX: (07) 8673006
CERTIFICATE NO: 9011192
DATE OF ISSUE: 1/24/2004

SPECIFICATION :		CUSTOMER :		AISI 304 INTEGRIS METALS LTD		Physical Properties Tensile Test GL-50 mm					Chemical Composition (%)							
(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Y.S. (N/mm ²)	T.S. (N/mm ²)	E.L. (%)	HRB	HV	C x100	SI x100	Mn x100	P x100	S x100	N x100	O x100	N x100
		KGS	LBS															
AISI 304 2B (7425-4228)	1	1,465	3,230	YU231320	3AS44453B-21	258	665	56	81	156	4.8	51	119	24	2	804	1821	2.7
24GA/48"X120"	1	1,464	3,228	YU231320	3AS44453B-22	258	665	56	81	156	4.8	51	119	24	2	804	1821	2.7
24GA/48"X120" (7425-5860)	1	1,464	3,228	YU230510	38637600B-61	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
28GA/48"X96" (7425-5950)	1	1,375	3,031	YU230510	38S37800B-52	280	673	53	82	162	5.4	50	126	26	3	815	1819	2.4
22GA/48"X120" (7425-5860)	1	1,445	3,186	YU134975	3AS43434A-1	312	666	51	82	161	4.1	49	112	24	2	809	1821	2.8
28GA/48"X96" (7426-2619)	1	1,497	3,300	YU231066	3AS42732-4	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA/48"X96" (7426-2619)	1	1,453	3,203	YU231066	3AS42732-5	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
18GA/48"X120"	1	1,455	3,208	YU231066	3AS42732-6	301	664	49	84	166	3.7	40	116	27	5	810	1824	3.7
16GA/48"X120" (7426-5166)	1	1,423	3,137	YU231143	3AS42886A-6	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120"	1	1,424	3,139	YU231143	3AS42886A-7	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X120" (7426-7949)	1	1,420	3,131	YU231143	3AS42886B-1	302	650	53	82	159	4.5	52	123	28	4	810	1822	2.7
16GA/48"X96" (7426-8053)	1	1,441	3,177	YU231075	3AS42917A-1	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
16GA/48"X96"	1	1,441	3,177	YU231075	3AS42917A-2	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
14GA/48"X120"	1	1,420	3,131	YU231075	3AS42917A-3	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
14GA/48"X120" (7426-8244)	1	1,420	3,131	YU231075	3AS42917A-4	302	650	52	83	162	4.2	48	119	26	6	806	1813	3.4
14GA/60"X96" (7426-8277)	1	1,446	3,188	YU135202	3AS45623A-211	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA/60"X120"	1	1,405	3,097	YU135202	3AS45823A-213	301	641	53	81	157	5.1	51	114	30	9	806	1822	3
14GA/60"X120"	1	1,540	3,395	YU135202	3AS45823A-214	301	641	53	81	157	5.1	51	114	30	9	806	1822	3

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Send test report for all Heat NO.
PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A362E, ASME SA240, Q35765D.

YIEH MAU CORP.
in *Yan Hsin*
Manager of Quality Assurance

2094 304 0455
(0.037)
po ~~267~~ 196



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8998 / 375 8111 Auckland
(08) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5210/22495

CUSTOMER	Wilkinson	P50323DI001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER O/N	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	480737		DIMENSIONS	0.055" x 48" x CoH	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000										x10000		x100	180°			G.L.=	HRB	()	(feet)
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm	(A)=C+Mn/8
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65% So (F)=8"	(B)=r90 (D)=(r0+r90+2r45)/4	(B)=7.5mm x 10mm	(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15
				(C)=C+Mn/8+Si/24
				(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC METALLURGIST

16 ga ms

POA 146, 267, 245,



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8989 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5379/23650

CUSTOMER Wilkinson		P50505-01002		SPECIFICATION ASTM A1008 CS Type A		Reissued 22/8/2005																		
CUSTOMER O/N 90-21N-742				PRODUCT CRA WIDE COIL		CERTIFICATE No TC116858																		
MILL O/N 486968				DIMENSIONS 0.033" x 48" x Coil		PAGE 1 of 1																		
						DATE 19 August 2005																		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)
R9-466080-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					180°						
R9-466081-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700
R9-466082-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				58		2700
R9-466083-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651
																		Good				47		2651

06-01-05

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm (B)=7.5mm x 10mm	(A)=C+Mn/6 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 x So (F)=8"	(B)=r90 (D)=(r0+r90+2r45)/4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	(C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Atish Misra
QC METALLURGIST

2094

PO# 267,146